

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017924**Date Inspected:** 11-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing (MT) – NWIT Document No's: 007309

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment 14E. The weld designations reviewed are as follows:

1. SEG3020AQ-026, 027, 028, 029

Magnetic Particle Testing (MT) – NWIT Document No's: 007310

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment 14W. The weld designations reviewed are as follows:

1. SEG3020AQ-026, 027, 028

Ultrasonic Testing (UT) – NWIT Document No: 007314

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This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Suspender Bracket. The weld designations reviewed are as follows:

1. SB023-104-003

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SB025-108-041 located on Suspender Bracket SB108E. ZPMC Welder is identified as 062755. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2231-Tc-U4b-F.

FCAW welding of weld joint SB018-100-025 and 031 located on Suspender Bracket SB100W. ZPMC Welder is identified as 062807. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SB018-096-031 located on Suspender Bracket SB096W. ZPMC Welder is identified as 062783. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SB021-098-061 and 049 located on Suspender Bracket SB098E. ZPMC Welder is identified as 058792. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SB0216-110-041 and 037 located on Suspender Bracket SB110W. ZPMC Welder is identified as 062755. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2231-Tc-U4b-F.

This QA inspector observed ABF personnel performed Magnetic Particle Testing on bottom cover plate of OBG Bike Path BK004A-007.

Shielded Metal Arc Welding (SMAW) repair welding of weld joint BK004A-007-019 located on bottom cover plate of OBG Bike path. ZPMC welder is identified as 259566. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-1G (1F) - Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-2103.

Shielded Metal Arc Welding (SMAW) repair welding of weld joint BK004A-007-020 located on bottom cover plate of OBG Bike path. ZPMC welder is identified as 259566. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-1G (1F) - Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-2137.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable

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contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Vibin	Quality Assurance Inspector
<b>Reviewed By:</b>	Patel,Hiranch	QA Reviewer

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